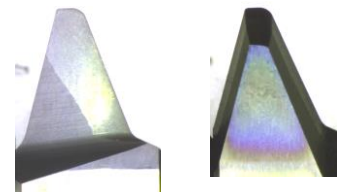
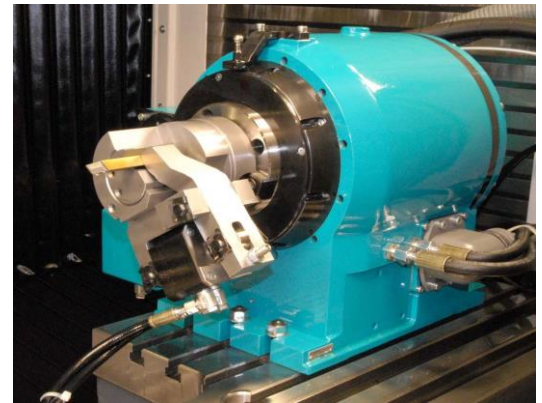


Gear Blade Oerlikon BxH 20.0 x 16.0

A12-350

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face. When inverting the operation on one of the sides, the complete profile can be preground with one side of the profile, preserving the opposite corner for finishing.



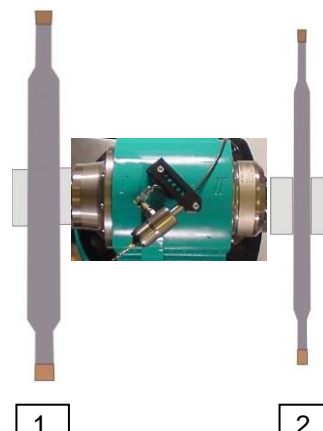
1. Cycletime for Resharpenering

Workpiece:	RH outer blade Spir; 20.0 x 16.0 x 115 mm					
Material	CARBIDE					
Operations	Probe	PrsSideRough	ClrSideRough	Prs.Side fin.	Clr.Side fin.	Face
Feed [mm/Min]	2000	80	80	85	85	75
Power [kW]		4.5	4.5	1.5	1.5	0.9
Cutting feed [m/s]		19	19	22	22	20
Used wheels		1	1	2	2	2
Grinding time [s]	18	50	50	42	42	46
Total cycle time	4 Min 08					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø250 D181
2	14A1 Ø250 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders :NGC

Control: Fanuc 300i

Accessories:

Responsible engineer:

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5



